

Date: Thursday, 08/05/2008 1:59:58 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SADDLE FITTING, FWD (OUTBOARD/INBOARD)
<b>Job Number</b> :	39122		
<b>Estimate Number</b> :	10530		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2571
<b>This Issue</b> :	08/05/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2571 REV E
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	38920	<b>Drawing Revision</b> :	E
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JUL 08.5.08</u>	<b>Due Date</b> :	30/05/2008
<b>Comment</b> :	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Qty: 8 Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D6101007	Saddle Billet
-----	----------	---------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 7075-T7351 8.25X7.75X2.5  
 Make from D6101-007 billet for D2571  
 Ensure that grain is along 7.75" length  
 Batch No: B34875

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. S.F Double check by: \_\_\_\_\_

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2571 & D2572

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 1:59:58 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 39122

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 08/05/19

(8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

20/1/18 08-05-20

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:15  
320° OF  
11:45

m-f 08/05/20

(8X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD 08/05/20

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57432 P-02/22 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/22

Job Completion



mf 08-05-22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 39120
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.441	0.442	0.442	0.443		
B	1.745	1.755		1.750	1.746	1.746	1.749		
C	3.495	3.505		3.500	3.499	3.499	3.500		
D	1.745	1.755		1.750	1.749	1.748	1.750		
E	7.990	8.010		8.003	8.003	8.003	8.002		
F	0.490	0.510		.510	0.5065	0.5045			
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.378	.377		
I	0.490	0.510		.505	.500	0.504	0.5045		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.570	0.571	0.571		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.500	1.500	1.500	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.875	3.875		
P	0.115	0.135		.120	.120	.123	.120		
Q	0.115	0.135		.135	.135	0.135	0.135		
R	0.240	0.260		.252	.249	.246	.250		
S	0.115	0.135		.123	.124	0.124	0.124		
T	0.178	0.198		.184	.188	.188	.188		
U	2.940	2.980		2.960	2.962	2.962	2.962		
V	0.230	0.250		.230	.234	0.230	0.230		
W	0.115	0.135		.125	.125	0.124	0.124		
X	0.308	0.313		0.309	0.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	0.364	0.365	0.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	0.629	0.6215	0.622		
AC	0.053	0.073		.063	.063	0.063	0.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.390	1.387	1.3885		
AF	0.115	0.135		.135	0.135	0.135	0.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.240	.242	0.238	0.242		
AI	2.000	2.020		2.000	2.001	2.002	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>JS</i>
Date: 08/05/14 / 08/05/15

Audited by: <i>J.F.</i>
Date: 08/05/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39122
<b>Description:</b> Saddle, Fwd Outboard		<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.438	0.443		0.443	0.443	0.443	0.443		
B	1.745	1.755		1.749	1.749	1.750	1.749		
C	3.495	3.505		3.498	3.499	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.748		
E	7.990	8.010		8.001	8.001				
F	0.490	0.510		0.506	0.505	0.505	0.506		
G	0.257	0.262		0.259	0.259	0.259	0.259		
H	0.375	0.380		0.378	0.378	0.378	0.378		
I	0.490	0.510		0.507	0.505	0.505	0.506		
J	1.174	1.184		1.179	1.179	1.180	1.180		
K	0.558	0.578		0.5715	0.572	0.572	0.572		
L	1.174	1.184		1.179	1.179	1.179	1.180		
M	1.490	1.500		1.499	1.500	1.499	1.499		
N	2.495	2.505		2.500	2.500	2.498	2.499		
O	3.869	3.879		3.874	3.874	3.875	3.875		
P	0.115	0.135		0.122	0.122	0.122	0.122		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.253	0.254	0.254		
S	0.115	0.135		0.125	0.127	0.127	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.958	2.958	2.960	2.960		
V	0.230	0.250		0.240	0.240	0.240	0.2415		
W	0.115	0.135		0.125	0.127	0.127	0.126		
X	0.308	0.313		0.309	0.309	0.309	0.309		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.365	0.365	0.365	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.622	0.6218	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.250	0.250	0.250		
AE	1.375	1.395		1.3875	1.388	1.389	1.389		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.247	0.249	0.249	0.253		
AI	2.000	2.020		2.002	2.003	2.0035	2.0035		
AJ	0.023	0.043							
Accept/Reject									

Measured by: <b>DTD</b>
Date: <b>08/05/15</b>

Audited by: <b>J.F.</b>
Date: <b>08/05/18</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED

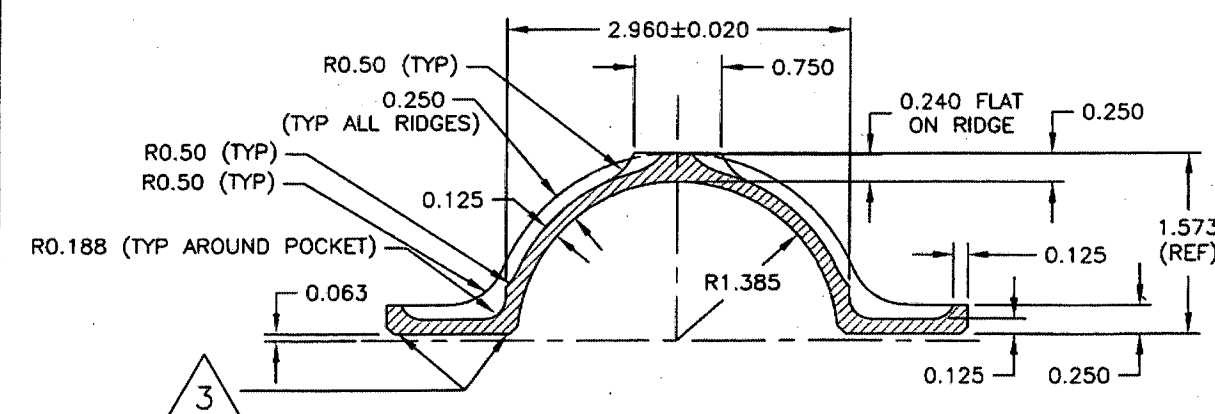
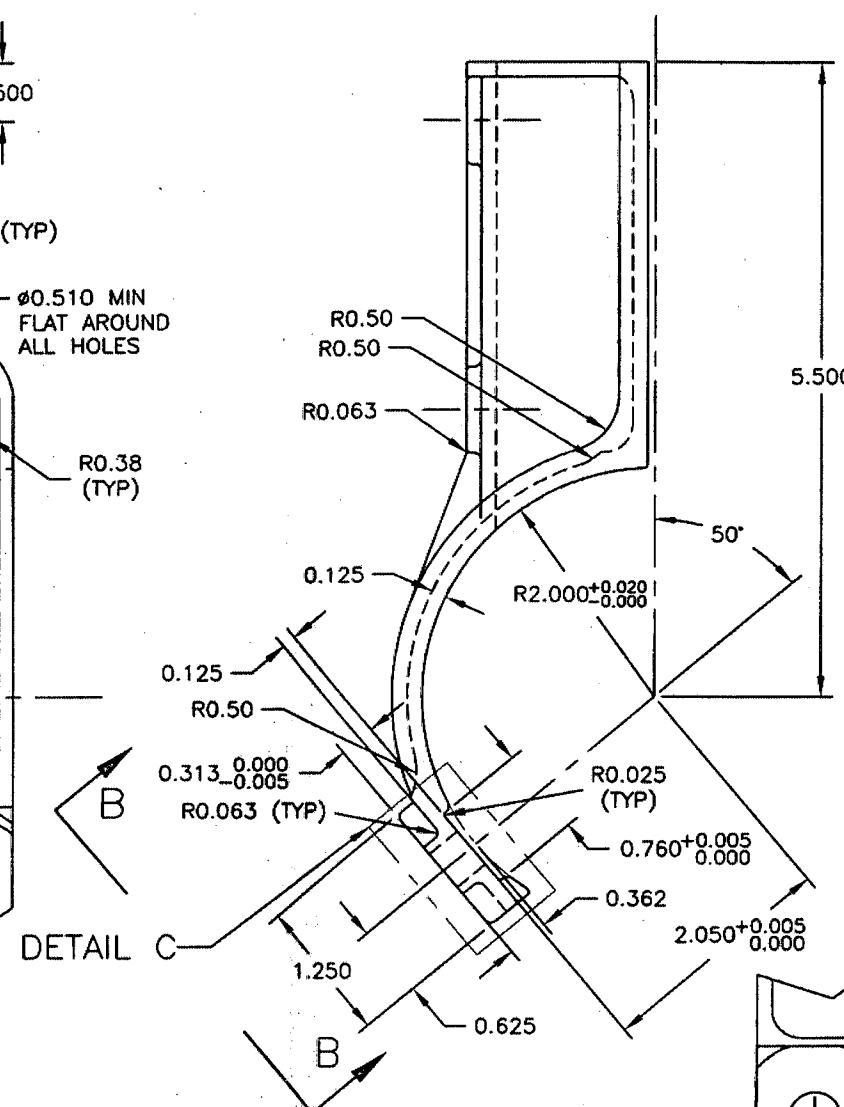
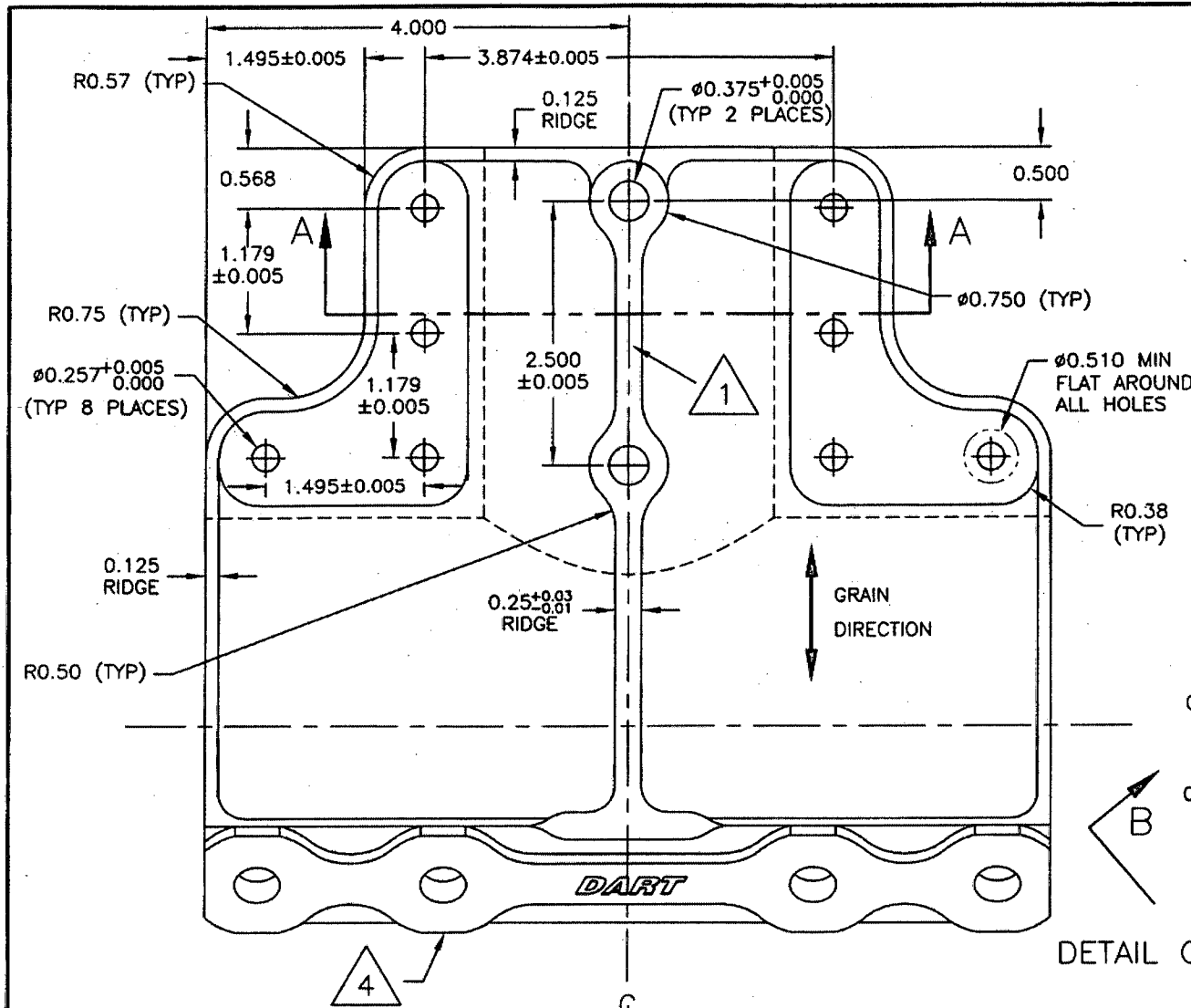
05-12-06

# NOTES

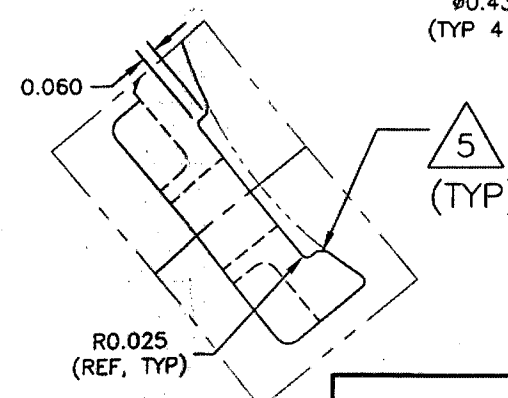
MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
 BREAK ALL SHARP EDGES 0.010 TO 0.020  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

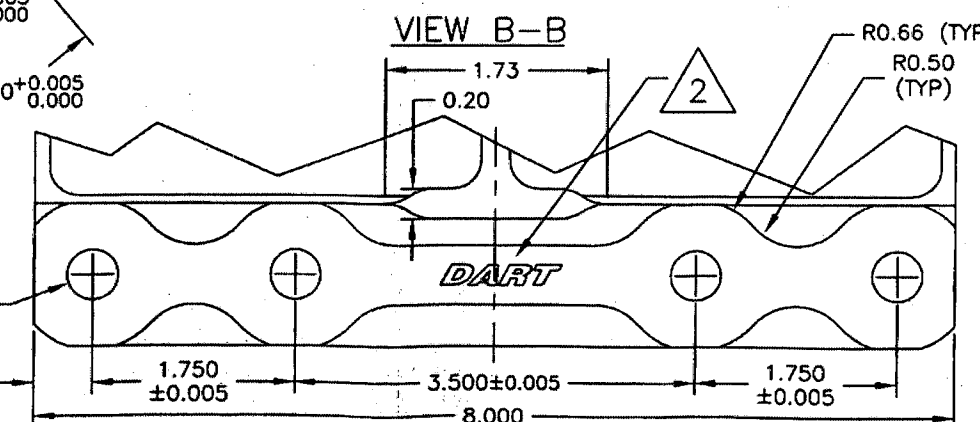
SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 39122



SECTION A-A



DETAIL C  
 SCALE 4:3



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	TITLE
		OUTER FWD SADDLE

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DART AEROSPACE LTD.  
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
 D2571

REV. E  
 SHEET 1 OF 1

SCALE  
 2:3